

Date: Thursday, 6/15/2006 1:50:02 PM  
 User: Kim Johnston

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> : BASKET BASE ASSEMBLY (350)          |
| <b>Job Number</b> : 27578A                              |   |
| <b>Estimate Number</b> : 10189                          |   |
| <b>P.O. Number</b> : N/A                                | <b>Part Number</b> : D2221                                |
| <b>This Issue</b> : 6/15/2006 <b>S.O. No.</b> : N/A     | <b>Drawing Number</b> : D2221/D2235                       |
| <b>Prsht Rev.</b> : NC                                  | <b>Project Number</b> : N/A                               |
| <b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY   | <b>Drawing Revision</b> : F/B1                            |
| <b>Previous Run</b> : 27577A                            | <b>Material</b> : N/A                                     |
| <b>Written By</b> : <i>SKA COMMENT Below</i>            | <b>Due Date</b> : 7/10/2006 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <i>06.06.15</i>      |   |
| <b>Comment</b> : Est Rev:J 05.09.02 Added D3442-1KJ/JLM |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |             |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 4   | D3166-1     | RIB         | <i>B21326</i> |

*PD 06-06-29 ①*

|     |        |              |
|-----|--------|--------------|
| 2.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

|     |             |               |               |
|-----|-------------|---------------|---------------|
| Qty | Part Number | Description   | Batch         |
| 2   | D2232-3     | Hinge bracket | <i>B21527</i> |

*PD 06-07-03 ①*

|     |       |                          |
|-----|-------|--------------------------|
| 3.0 | D2325 | Support Gusset (350 Bask |
|-----|-------|--------------------------|



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

|     |             |                |                |
|-----|-------------|----------------|----------------|
| Qty | Part Number | Description    | Batch          |
| 4   | D2325       | Support Gusset | <i>B216741</i> |

*PD 06-07-03 ①*

|     |        |                |
|-----|--------|----------------|
| 4.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 2   | D2327-3     | Bushing     | <i>B21051</i> |

*PD 06-07-03 ①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date:  
User:

1:50

## Process Sheet

Customer: CO-20001

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27578A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B27524

PD

06-07-03

(1)

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B26739

PD

06-07-03

(1)

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M101358

PD

06-07-05

(1)

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M101309

M100138 -> 37.76"

PD

06-06-29

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-07-06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:50:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27578A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

11/06/07/07 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DU SC 06/07/12 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/07/17 ①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291

Batch: M101193

Expiry date: 11/06

SAD 06/07/13

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

11/06.07.18

Job Completion



12 06.07.17

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



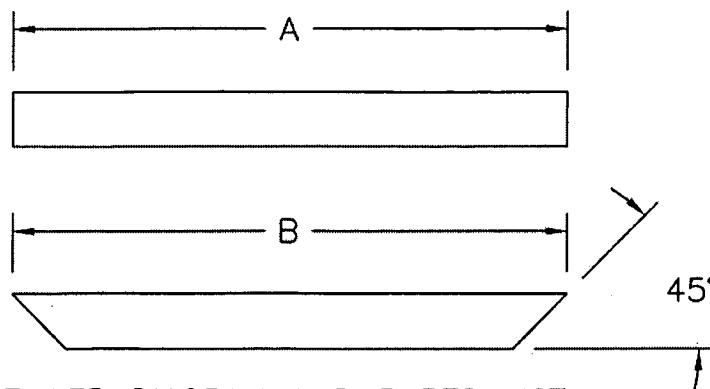
|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br>PH                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2221                                      | REV. F<br>SHEET 1 OF 3 |
| DATE<br>05.06.07              |                                | TITLE<br>BASKET BASE ASSEMBLY (350)                       | SCALE<br>NTS           |
| C                             | 95.11.21                       | SEPARATE BASKET AND LID                                   |                        |
| D                             | 96.06.21                       | CHANGE LATCH  |                        |
| E                             | 01.04.19                       | CHANGE HINGE  |                        |
| F                             | 05.06.07                       | ADD SHIM UNDER HINGES,<br>ADD HOLES FOR SPLIT LID BASKETS |                        |

RELEASED

05.08.19 *[Signature]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH<br>A | LENGTH<br>B | DESCRIPTION    |
|---------|----------|-------------|-------------|----------------|
| D2221-1 | 2        | —           | 96.00       | RIB            |
| D2221-3 | 2        | —           | 25.50       | RIB            |
| D2221-5 | 2        | 18.88       | —           | RIB            |
| D2221-7 | 1        | 55.25       | —           | RIB            |
| D2232-3 | 2        | N/A         | N/A         | HINGE PLATE    |
| D2235-1 | 4        | N/A         | N/A         | RIB            |
| D2325   | 4        | N/A         | N/A         | SUPPORT GUSSET |
| D2327-3 | 2        | N/A         | N/A         | BUSHING        |
| D2581   | 2        | N/A         | N/A         | MTG BRKT       |
| D3442-1 | 2        | N/A         | N/A         | SHIM           |



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\varnothing 0.257$  HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID



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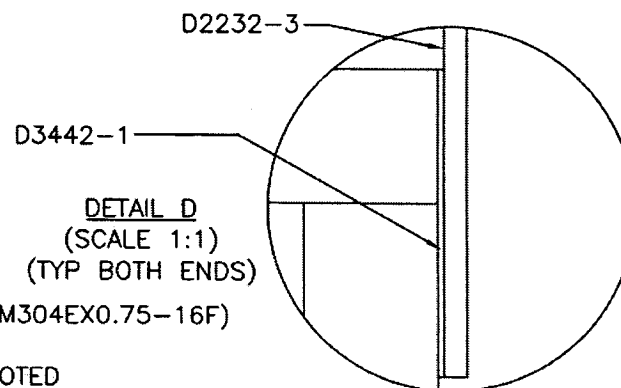
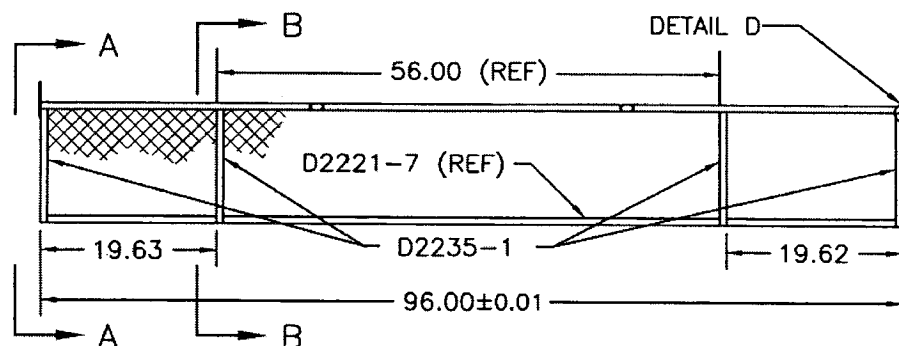
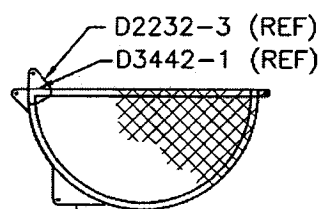
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|----------|---|----------|---|--|--------------|
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| CHECKED  |  | APPROVED |  | DRAWING NO.  | REV. F       |
|          |   |          |   | D2221  | SHEET 2 OF 3 |
| DATE     |   |          |   | TITLE  | SCALE        |
| 05.06.07 |   |          |   | BASKET BASE ASSEMBLY (350)                               | 1:20         |



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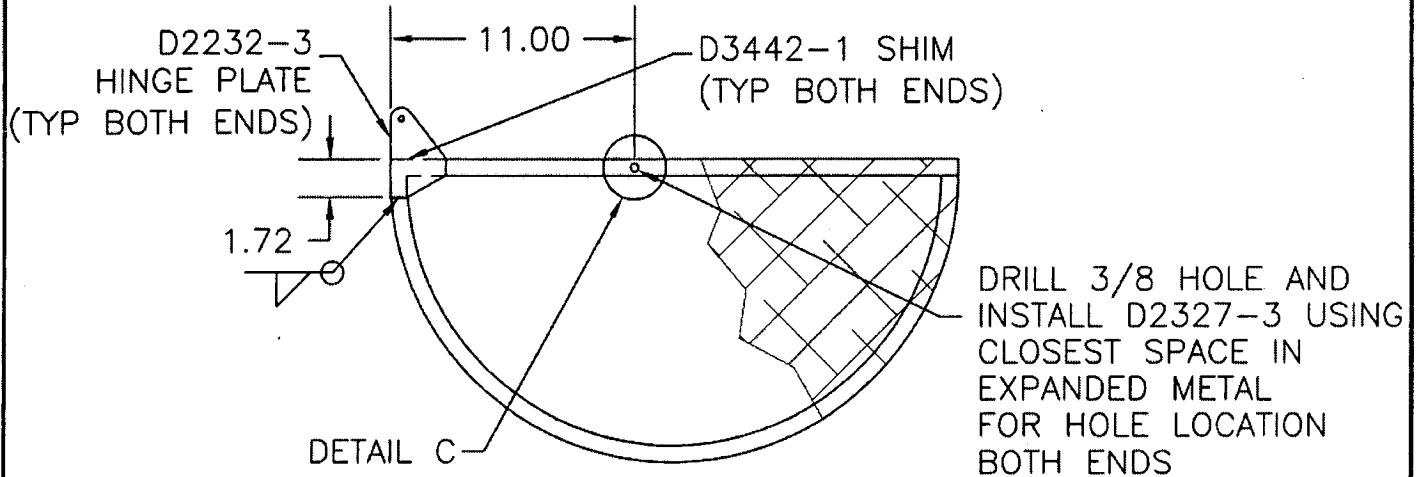
D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

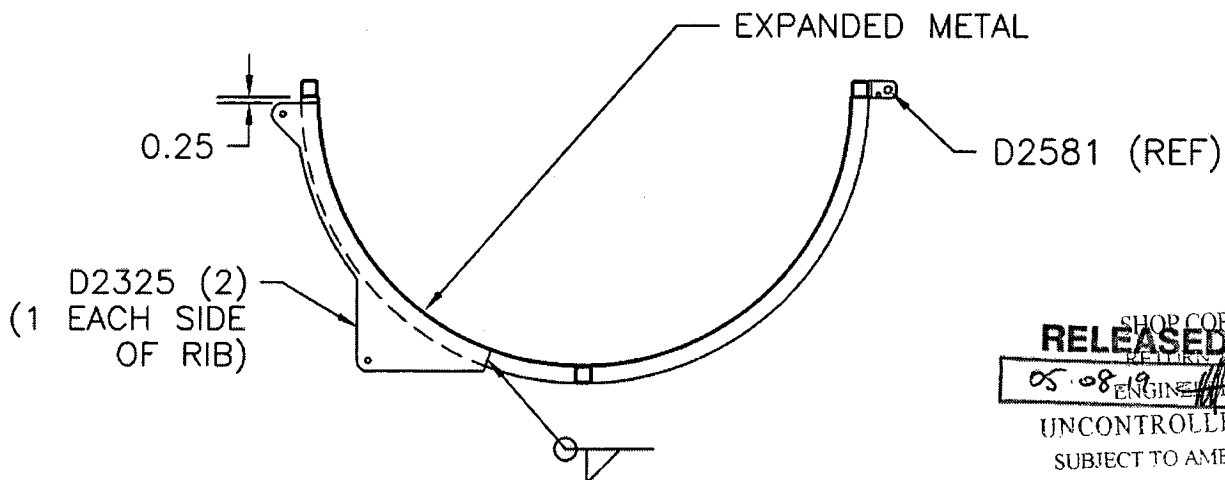
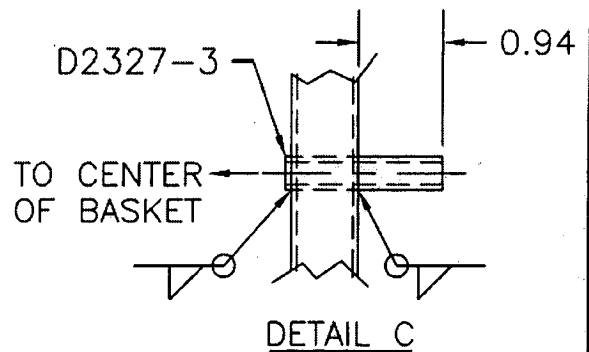


**DART**

|                        |                                     |   |                        |
|------------------------|-------------------------------------|---|------------------------|
| DESIGN<br>BW           | DRAWN BY<br>PH                      | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature]             | DRAWING NO.<br>D2221                              | REV. F<br>SHEET 3 OF 3 |
| DATE<br>05.06.07       | TITLE<br>BASKET BASE ASSEMBLY (350) |   | SCALE<br>1:8           |



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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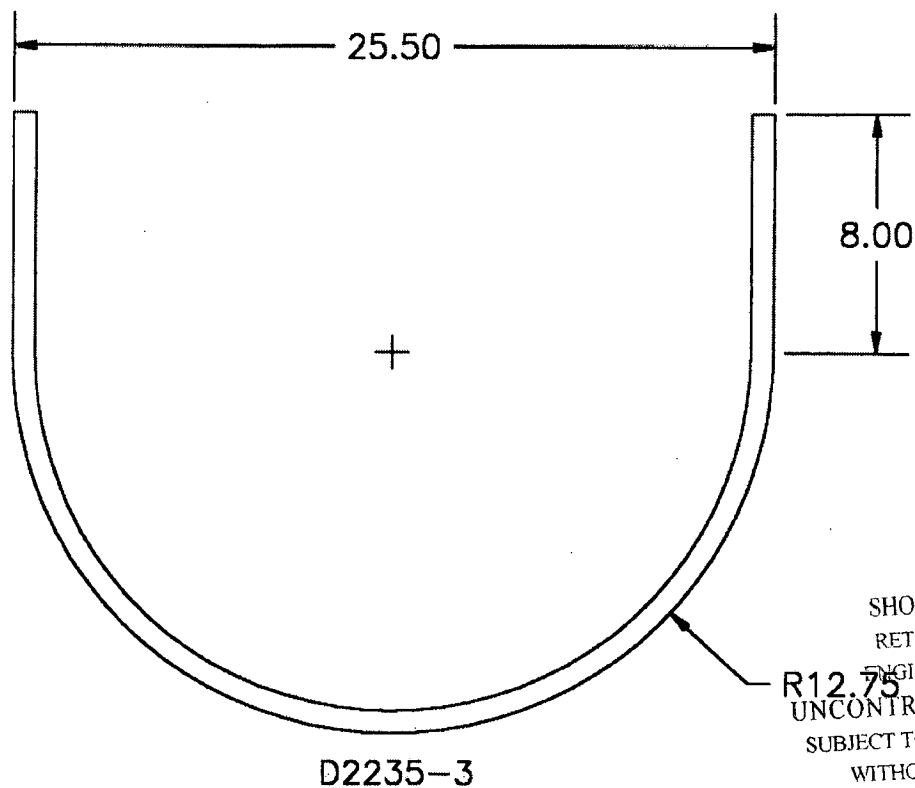
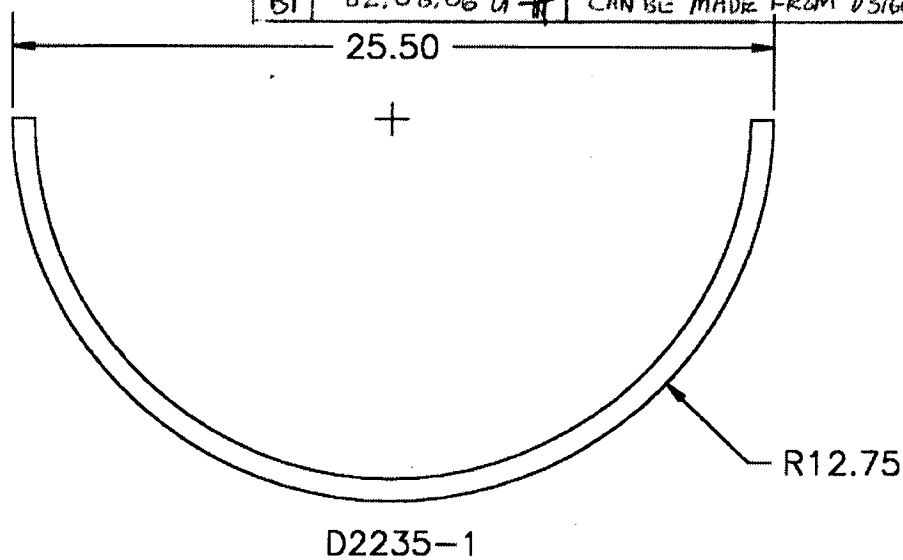
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|                    |                             |  |              |
|--------------------|-----------------------------|--|--------------|
| DESIGN             | DRAWN BY                    | DART AEROSPACE LTD                     |              |
| B WILLIAMS         | B WILLIAMS                  | VICTORIA INTERNATIONAL AIRPORT, CANADA |              |
| CHECKED            | APPROVED                    | DRAWING NO.                            | REV. B       |
| <i>[Signature]</i> | <i>[Signature]</i>          | D2235                                  | SHEET 1 OF 1 |
| DATE               | TITLE                       |  | SCALE        |
| 94:12:16           | BASKET RIBS                 |  |              |
| BI                 | 02.08.06 <i>[Signature]</i> | CAN BE MADE FROM D3166-1               |              |

RELEASED  
R 960507



CAN BE MADE FROM D3166-1 *[BI]*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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